

Date: Wednesday, 29/10/2008 7:59:58 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHORT T-HANDLE ASSY
Job Number	: 43053-2	Part Number	: PB674300163
Estimate Number	: 13529	Drawing Number	: B6743001 P.15
P.O. Number	:	Project Number	: N/A
This Issue	: 29/10/2008 S.O. No. :	Drawing Revision	: B1
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : LARGE FAB ASSY	Due Date	: 05/11/2008
Previous Run	: 41384	Qty:	1/2 Um: Each
Written By	:		
Checked & Approved By	: <u>mf 08-10-29</u>		
Comment	: Est Rev:A 08-07-29 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001131	Tube End Cap
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Tube End Cap
 batch: 41480 ✓

mf 08-11-11

2.0	PB6743001129	Tube Handle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Tube Handle
 batch: 40019 ✓

mf 08-11-11

3.0	PB6743001127	Handle Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Handle Arm
 batch: 44479 B40015 x 1 *

mf 08-11-11

4.0	PB6743001157	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Tube
 batch: 40026 ✓

mf 08-11-11

5.0	CR321342	Cherry Rivet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Cherry Rivet
 batch: m102569 ✓

mf 08-11-11

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- chamfer both ends (0.090") on -129 and -127
- 2- chamfer (0.090") only the angle end on -157
- 3- drill #40 hole in center of -129 before welding -131 caps, to let air out
- 4- weld -131 to -129 as per dwg
- 5- grind weld flush
- 6- assemble -127 under the pilot hole in -129 and -157 weld as per dwg
- 7- grind weld flush
- 8- install rivet as per dwg

(X1)

Pl 08-11-13

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/11/14 (1)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/11/14 (1)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M102316

(1X)

****mask only -157 starting from rivet to end of -157 tube, rivet must be powder coat****

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:30
220 OF
12:30

M-L 08/11/14

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 08-11-17

11.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

SPRING SLOTTED PIN

batch: M17850

MF 08-11-14

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Job Number: 43053

Part Number: PB674300163

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PB6743001133

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Clevis

batch: 23994

ST

MF 08-11-14

13.0

PB6743001137

Locking Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Locking Sleeve

batch: 40023

ST

MF 08-11-14

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble by drilling thru both -157 and -133 as per dwg

2- install spring slotted pin as per dwg

SMD 08-11-17

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SOSLU18 (U)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

P- 8 Jul 19 (U)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/20 JF

Job Completion



MF 08-11-19

ORIGINAL



